

Duplicate

Work Order ID 94286

94286

February-19-13 7:06:29 AM

Item ID: D205-708-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Adjustable Engine Mount

Start Date: 12/05/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/15/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B80701	Rev C
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100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D205-708-011, CHG001

DAS 15 9-89
13222

2
CK Rev 13/2/22

110

0.00

110

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O:	for:
6 D3284-001	(B80702-1) Sleeve
2 D3284-003	(B80703-1) Stud
4 D3284-005	(B80704-1) Stud
6 D3284-007	(B80705-1) Stud
6 NAS509-12	Nut
6 NAS509L12	NutStud

N/A
130222

To be assembled as per Dwg B80701 Rev. C
Possible Supplier: Northern Aero
Certificate of Conformity is required

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.00							
Packaging	Receive & Inspect For Transit Damage Ensure Certificate of Conformity is attached								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control	Inspect assembly. Visually inspect thread, fit and cad plating								
135	Pick Kit	0.00							
135									
Packaging	Memo	0.00							
Packaging									

13-2-19

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Item ID: D205-708-011

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Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Adjustable Engine Mount

Start Date: 12/05/12 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 2/15/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				2			
150 *150* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D205-708-011 Location: _____ PPP Rev: _____	0.00 0.00				2x			
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

M/B-02-22

Picklist Print

*February-19-13 7:06:28 AM

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Work Order ID: 94286

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Start Date: 12/05/12

Required Date: 2/15/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C 06.01.31 Added MS206136C12 JLM/AP
IPP Rev:D 07-12-12 as per ECN 1074 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3284-001 Sleeve		Manufactured	No			140	Each	36.0000	6	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		36							
				37468		36							
D3284-003 Stud		Manufactured	No			140	Each	4.0000	2	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		4							
				32724		1							
				94311		3							
D3284-005 Stud		Manufactured	No			140	Each	45.0000	4	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		45							
				24757		40							
				43645		3							
				79831		2							
D3284-007 Stud		Manufactured	No			140	Each	36.0000	6	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		36							
				55437		36							
D3284-009 Bearing		Manufactured	No			140	Each	94.0000	6	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		94							
				24757		30							
				91712		16							
				94442		48							

Picklist Print

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Work Order ID: 94286

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Start Date: 12/05/12

Required Date: 2/15/13

Start Qty: 2.00

Required Qty: 2.00

~~D3284-011~~

Bearing

Manufactured No

140 Each 16.0000

0

2

Location

Loc Qty

Loc Code

ST037

16

24776

5

60004

3

94443

8

Purchased No

140 Each 79.0000

Location

Loc Qty

Loc Code

ST312

79

100089

10

105433

69

Purchased No

140 Each 500.0000

Location

Loc Qty

Loc Code

ST312

500

115358

416

19096

12

19392

72

Purchased No

140 Each 53.0000

Location

Loc Qty

Loc Code

ST312

53

124343

50

19573

3

Purchased No

140 Each 112.0000

Location

Loc Qty

Loc Code

ST312

112

124343

75

15921

5

16255

2

19349

30

~~MS20613-6G12~~

RIVET

Purchased No

140 Each 79.0000

Location

Loc Qty

Loc Code

ST312

79

100089

10

105433

69

Purchased No

140 Each 500.0000

Location

Loc Qty

Loc Code

ST312

500

115358

416

19096

12

19392

72

Purchased No

140 Each 53.0000

Location

Loc Qty

Loc Code

ST312

53

124343

50

19573

3

Purchased No

140 Each 112.0000

Location

Loc Qty

Loc Code

ST312

112

124343

75

15921

5

16255

2

19349

30

~~MS20613-6G18~~

Rivet

Purchased No

140 Each 53.0000

Location

Loc Qty

Loc Code

ST312

53

124343

50

19573

3

Purchased No

140 Each 112.0000

Location

Loc Qty

Loc Code

ST312

112

124343

75

15921

5

16255

2

19349

30

~~MS20613-6G19~~

Rivet

Purchased No

140 Each 112.0000

Location

Loc Qty

Loc Code

ST312

112

124343

75

15921

5

16255

2

19349

30

Shop Packet Print

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Picklist Print

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Start Date: 12/05/12

Required Date: 2/15/13

Start Qty: 2.00

Required Qty: 2.00

NAS509-12
Nut

Purchased

No

140

Each

91.0000

12

Location

Loc Qty

Loc Code

ST

12

91674

12

ST276

79

15057

43

24757

36

Purchased

No

140

Each

67.0000

12

Location

Loc Qty

Loc Code

ST

12

91674

12

ST276

55

102296

16

15062

9

24757

30

NAS509-12
Nut

4.0 PARTS LIST

Qty -043	Qty -013	Qty -041	Qty -011	Part Number	Description
			X	D205-708-011	ADJUSTABLE ENGINE MOUNT KIT (205/UH-1)
		X		D205-708-041	ADJUSTABLE ENGINE MOUNT ASSEMBLY (205/UH-1)
	X			D204-708-013	ADJUSTABLE ENGINE MOUNT KIT (204)
X				D204-708-043	ADJUSTABLE ENGINE MOUNT ASSEMBLY (204)
	6		6	D3284-001	SLEEVE
			2	D3284-003	STUD
	6		4	D3284-005	STUD
	6		6	D3284-007	STUD
	6		6	D3284-009	BEARING
	1		1	D3284-011	BEARING
1				D3284-021	TUBE ASSEMBLY
1				D3284-023	BIPOD ASSEMBLY
1				D3284-025	TRIPOD ASSEMBLY
		1		D3284-031	TUBE ASSEMBLY
		1		D3284-033	BIPOD ASSEMBLY
		1		D3284-035	TRIPOD ASSEMBLY
	2		2	MS20613-6C12	RIVET
	12		8	MS20613-6C16	RIVET
			8	MS20613-6C18	RIVET
	12		8	MS20613-6C19	RIVET
	6		6	NAS509-12	NUT
	6		6	NAS509L12	NUT

5.0 WEIGHT AND BALANCE

The following is the net weight and moment change associated with this installation

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-708-011 Adjustable Engine Mount Kit (205/UH-1)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	188.5 in 4.79 m	1810 lb-in 21.1 kg-m
D205-708-041 Adjustable Engine Mount Assembly (205/UH-1)					
D204-708-013 Adjustable Engine Mount Kit (204)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	184.5 in 4.69 m	1771 lb-in 20.6 kg-m
D204-708-043 Adjustable Engine Mount Assembly (204)					